

Work Order ID 52548

September 30, 2009 10:24:45 AM



Page 1

Item ID: D3655-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: PANEL

Start Date: 30/09/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 15/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date: 09-9-30

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3655

Rev B

100

0.00



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks to fit frame size

BB
09/10/14 (X4)
(X1)

110

0.00



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D3655-3 and Folio FTA-017 using tool DT
8985 □ Dwg. Rev. B □ Folio Rev. A

BB
09/10/20 (X5)

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Visually inspect for proper formation of each part

BB
09/10/20 (X5)

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Required Date: 15/10/2009 Req'd Qty: 4.00



Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

DL 09/10/20
X5

140

HAND FINISHING THERMOFORMING

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions as per dwg D3655

BB 09/10/20
X5

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Check dimensions to ensure conformity to drawing tolerances.

BB 09/10/20
X5

Work Order ID 52548

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Item ID: D3655-3

Accept

Revision ID: B

Item Name: PANEL

Start Date: 30/09/2009 Start Qty: 4.00

Required Date: 15/10/2009 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	28 Oct 10/22			(25)	7		
170 Packaging Packaging	Identify as per dwg & Stock Location: 52548 PDP	0.00 0.00				9/10/22	(5K)		
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				09/10/23			

09/10/23
PO 09-10-23

Picklist Print

September 30, 2009 10:24:44 AM

Page 1

Work Order ID: 52548

Parent Item: D3655-3RevB

Parent Item Name: PANEL

Comments:

Start Date: 30/09/2009

Required Date: 15/10/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,385.812	138.6400			
GE PLASTICS LEXAN SHEET												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

1385.812653

107574

16.62

111973

190.526053

112176

1178.6666

5

B 09/10/20

DART AEROSPACE LTD		Work Order: 52548
Description: Panel		Part Number: D3655-3
Inspection Dwg: D3655 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB **Date:** 09/10/20

TRIMMING SECTION

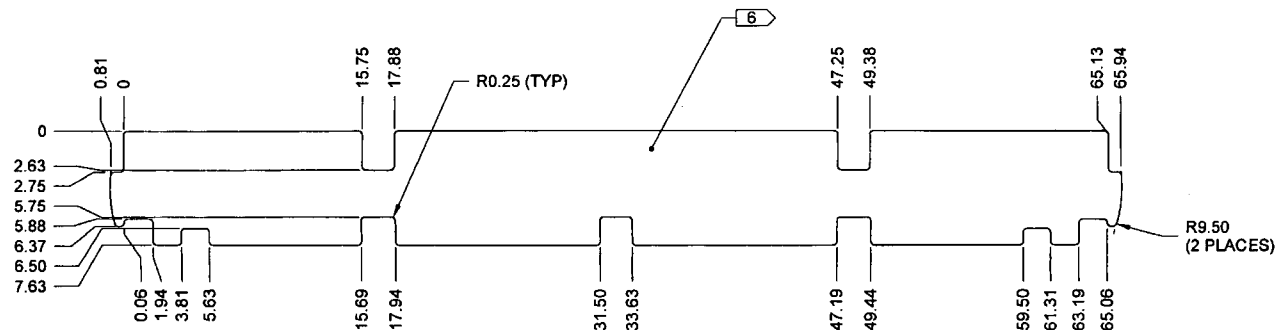
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
67.9	+/-0.100	67.885	✓			
25.0	+/-0.100	25.09	✓			
44.5	+/-0.100	44.5	✓			
0.070	Min	.094	✓			
0.050	Min	.058	✓			

Measured by: BB **Date:** 09/10/20

Audited by: Dh **Date:** 09/10/20

Prototype Approval: N/A **Date:** N/A

Rev	Date	Change	Revised by	Approved
A	09.06.11	New Issue	KJ	M



D3655-1 PANEL

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 525718

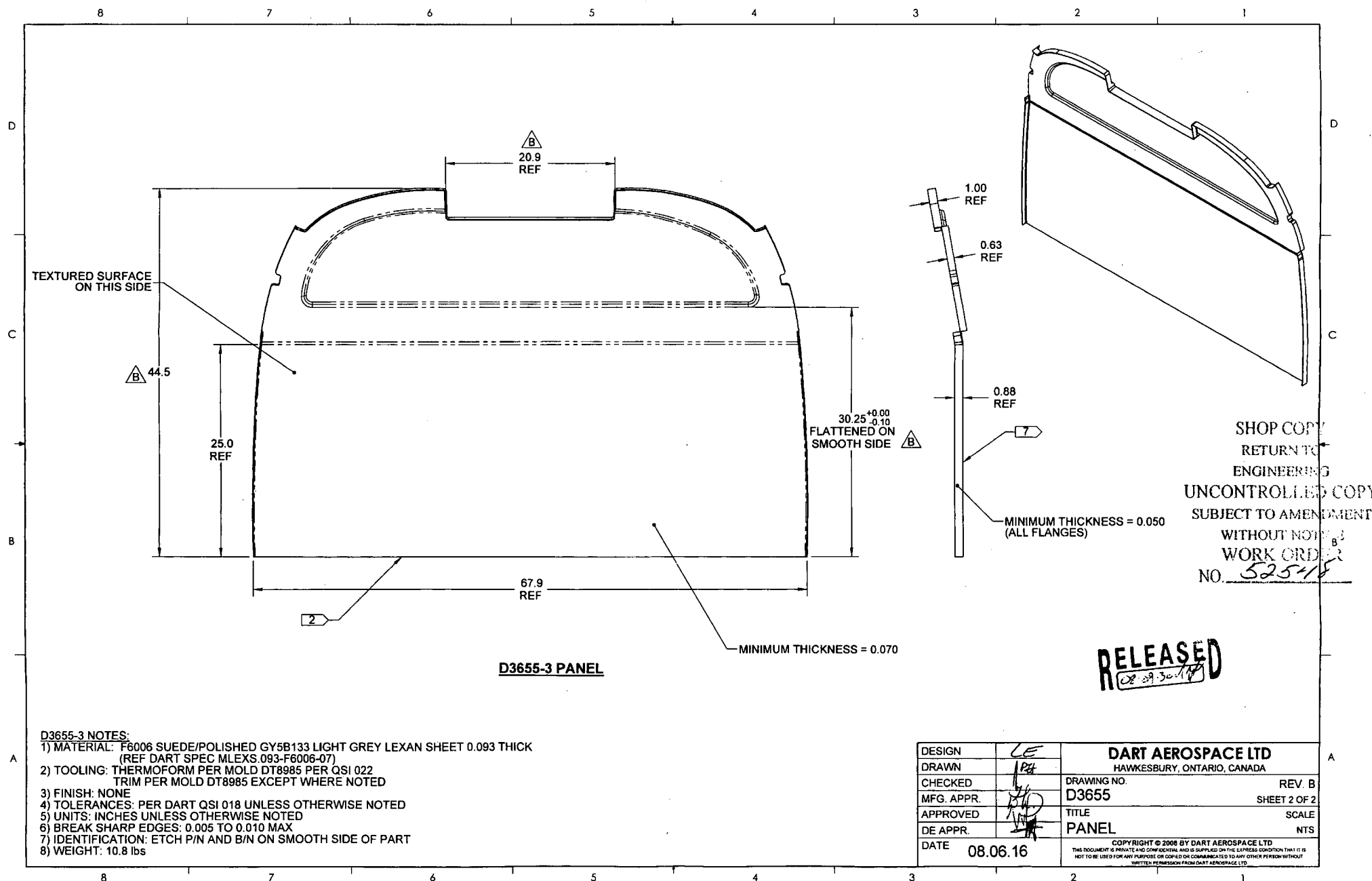
09-9-30

RELEASED
08-09-30/17

D3655-1 NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 7) WEIGHT: 1.8 lbs

REV.	DESCRIPTION	BY	DATE
B	44.5 WAS 45.5 (ZN C8-2); 20.9 WAS 19.9 (ZN D5-2); DELETE REFERENCE DIMENSION 2.4 (ZN D6-2); ADD 30.25 DIMENSION FOR TRIMMING (ZN C3-2); REASON: DRAFTING ERROR	PH	08.06.16
A	NEW ISSUE	LE	08.03.03
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE			
08.06.16			
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3655			
TITLE PANEL			
REV. B			
SHEET 1 OF 2			
SCALE NTS			
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WORK ORDER
NO. 52545

D3655-3 NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) TOOLING: THERMOFORM PER MOLD DT8985 PER QSI 022
TRIM PER MOLD DT8985 EXCEPT WHERE NOTED
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: ETCH P/N AND B/N ON SMOOTH SIDE OF PART
- 8) WEIGHT: 10.8 lbs

DESIGN	CE	DART AEROSPACE LTD	
DRAWN	1/24	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3655	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
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